

Work Order ID 79406

Wednesday, January 25, 2012 3:06:05 PM

79406

Page 1

Item ID: D206-642-612

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Float Skidtube RH

Stop ***N100***

Start Date: 1/25/2012 Start Qty: 1.00

1

Cust Item ID:

Required Date: 1/31/2012 Req'd Qty: 1.00

1

Customer:

Reference: REWORK

Approvals: Process Plan: *MF*

Date: *12-01-25* Tooling:

Date:

QC:

Date: SPC (Y/N):

Date:

DART				TEL: 1-618-632-3336 FAX: 1-618-632-4443	
TRANSPORT CANADA APPROVAL # 09-89					
P/N	D206-642-612	CHG	CHG003		
DESC	Float Skidtube RH	STC	SH98-4		
LOT	B36178	STC	SA00475SE		
MODEL	Bell 206A/B	STC			
US PATENT # 5735484 CANADA FOREIGN PATENTS PENDING				MADE IN CANADA	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
IIN D206-642	0

150 *LD* 0.00

150

HandFinish
Hand Finishing

Memo
PULL FROM STOCK D206-642-612 B 36178

REMOVE CAP AND WASH LPS3 OUT OF TUBE PER ECN 09-616

CHG003

160 QC5- Inspect part completeness to step on W/O 0.00

160

QC
Quality Control

Memo 0.00

170 0.00

170

HandFinish
Hand Finishing

Memo 0.00

RE-ASSEMBLE I D2646 Aft Cap and seal with Sikaflex. Clean excess adhesive.

A/R Sikaflex-291 *119508*

Sikaflex expire date: *12/08*

12-01-30 (1)

for MJS 12-1-31

12-01-31 (1)

A8 12-1-31

B79406 D206-642-612

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 79406***79406***

Page 2

Wednesday, January 25, 2012 3:06:05 PM

Item ID: D206-642-612

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Float Skidtube RH

Start Date: 1/25/2012 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 1/31/2012 Req'd Qty: 1.00 ***1***

Customer:

Reference: REWORK

Approvals: Process Plan: Date: Tooling: Date:

Run Start ***NR1***

QC: Date: SPC (Y/N): Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

180

QC5- Inspect part completeness to step on W/O

0.00

180

QC

Memo

0.00

Quality Control

12 - 01 - 31 (1)

190

Pick Kit

0.00

190

Packaging

Memo

0.00

Packaging

REMOVE D3672-5 X 16
AND REPLACE WITH D3672-7 X 16
PER DSI 9467 (ECN 09-616)

12/21/12

200

QC4- 100% Inspect kits for completeness

0.00

200

QC

Memo

0.00

Quality Control

5/2/02/01

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 79406***79406***

Page 3

Wednesday, January 25, 2012 3:06:05 PM

Item ID: D206-642-612

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Float Skidtube RH

Start Date: 1/25/2012 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 1/31/2012 Req'd Qty: 1.00 ***1***

Customer:

Reference: REWORK

Approvals: Process Plan: Date: Tooling: Date:

Run Start ***NR1***

QC: Date: SPC (Y/N): Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

210

Identify as per dwg & Stock Location: _____

0.00

210

Packaging

Memo

0.00

Packaging

ID AND STOCK UNDER NEW BATCH NUMBER AND NEW CHANGE
NUMBER

CHG 004

ADD NEW PAPERWORK

SP 12-02-01

220

QC21- Final Inspection - Work Order Release

0.00

220

QC

Memo

0.00

Quality Control

MLJ 12/02/01

12-02-01

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Wednesday, January 25, 2012 3:06:05 PM

Page 1

Work Order ID: 79406

Parent Item: D206-642-612

Parent Item Name: Float Skidtube RH

Start Date: 1/25/2012

Required Date: 1/31/2012

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:B05.10.27 Revised pick list KJ/EC
 IPP Rev:C 07-02-23 As per IIN D206-642 Rev K JLM
 IPP Rev:D 07-12-05 ECN 1080p Rev:L DD verified by:ec
 IPP Rev:E 09-01-06 update part list DD verified by:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3672-5 Phenolic Washer		Manufactured	No				Each	1,864.0000		-16			

Location	Loc Qty	Loc Code
ST060	1864	
35521	1075	
44679	220	
50354	569	

D3672-7 Phenolic Washer		Manufactured	No				Each	1,068.0000					
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Location	Loc Qty	Loc Code
ST060	1068	
73488	68	
76279	1000	

10

12/2/16

10

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Qty -041	Part Number	Description
X	D3288-041	SKIDTUBE ASSEMBLY
1	D2600-1-240	EXTRUSION
1	D2646	AFT CAP
1	D2647	CAP
9	D2649	CROSS BOLT SPACER
6	D3275-1	CROSS BOLT SPACER
2	D3286-1	DOUBLER
2	D3286-3	SPACER
1	D3289-041	FLOAT WEB
1	D3413-1	RING
1	D3415-041	NUT PLATE
1	D3535-15	WEARSHOE
1	D3535-21	WEARSHOE
1	D3535-35	WEARSHOE
1	D3535-41	WEARSHOE
1	D3536-15	GASKET
1	D3536-21	GASKET
1	D3536-35	GASKET
1	D3536-41	GASKET
7	D3537-1	WEARPAD
1	D3537-3	WEARPAD
12	D3683-1	INSERT
64	ALS7-1032-130	INSERT (or AKS4-1032-130, ALS4-1032-130, AELS-1032-130)
66	AN3C4A	BOLT
1	AN4C5A	BOLT
1	AN960C416	WASHER
78	AN960C10L	WASHER
2	CCR264SS3-3	RIVET
2	CR3212-4-03	RIVET
52	CR3212-4-04	RIVET
12	MS27039C1-05	SCREW (or AN3C3A BOLT)
2	NAS1515H3L	WASHER

GENERAL NOTES:

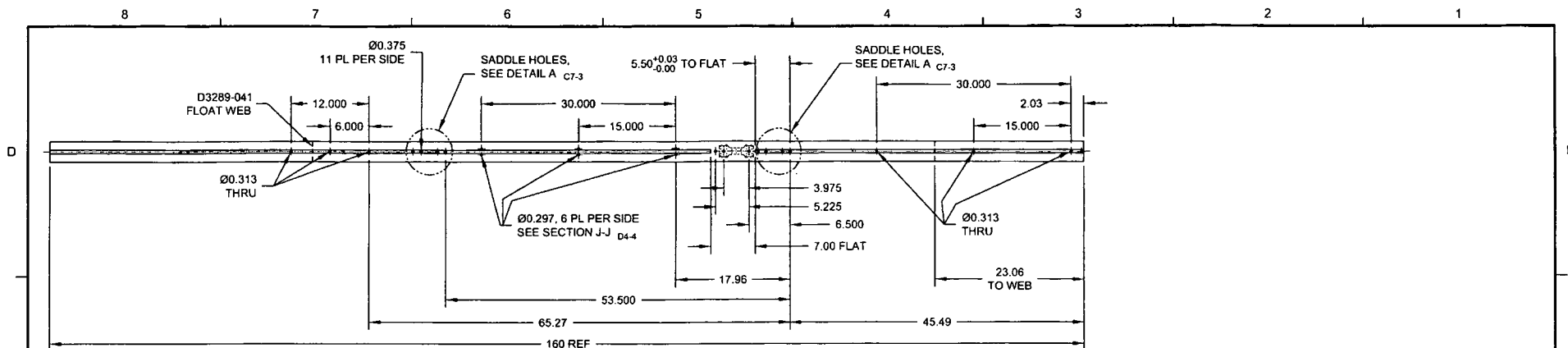
- MATERIAL: N/A
- FINISH: ACID ETCH, ALODINE ASSEMBLY PER DART QSI 005 4.1
POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3
- TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- UNITS: INCHES UNLESS OTHERWISE NOTED
- BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- IDENTIFICATION: NONE
- WEIGHT: 20.8 LBS
- DAMAGE TOLERANCE ON FWD BEND:
THERE SHOULD BE NO VISIBLE WRINKLES IN THE BEND FROM THE GROUND TO A HEIGHT OF 5 INCHES ABOVE THE GROUND. IT IS ACCEPTABLE TO POLISH OUT GOUGES UP TO 0.020 DEEP IN THE BENT PORTION OF THE TUBE. A MAXIMUM REDUCTION IN DIAMETER OF 0.150" IS ACCEPTABLE IN THE BENT PORTION OF THE TUBE.
- BOND D3289-041 FLOAT WEB INTO D3288-1 OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241/291 ADHESIVE PER DART QSI 015. ENSURE HOLES LINE-UP.
- ALL HOLES DRILLED ON CENTERLINES EXCEPT WHERE SHOWN
- DRILL Ø0.297 HOLES FOR D3683-1 INSERTS BEFORE FINISH. INSTALL D3683-1 INSERTS AFTER FINISH
- DRILL Ø0.297 HOLES FOR ALS7-1032-130 INSERTS USING DT3288-1T2 BEFORE FINISH. INSTALL ALS7-1032-130 INSERTS AFTER FINISH. SEAL WEARSHOE BOLTS WITH SIKAFLEX -241/-291
- WELDING: PER DART QSI 004
- COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF POWDER COATING WITH MEK DEGREASER.

G	REFORMAT DWG, RMV LPS-3 (ZN B6-3) RMV C'BORE & ADD SECTION K-K (ZN C2-4)	CP	09.06.17
F	SUBSTITUTE FLOAT BAG INSERT W/SPEC CTRL DWG WAS ALS7-1032-130; IS NOW D3683-1	DC	07.11.21
E	MID-FLOAT HOLES WERE MOVED 2.00" FWD AND ROTATED INBOARD AND OUTBOARD BY 17° INSERTS ARE NOW INSTALLED AT THESE LOCATIONS	MB	07.09.14
D	DIMENSIONS ADDED	DC	07.06.04
C	NEW INSERTS, SS WEARSHOES AND GASKETS	PH	06.12.19
B	CHANGE INSERTS	CP	05.03.18
A	NEW ISSUE	CP	04.05.17
REV.	DESCRIPTION	BY	DATE

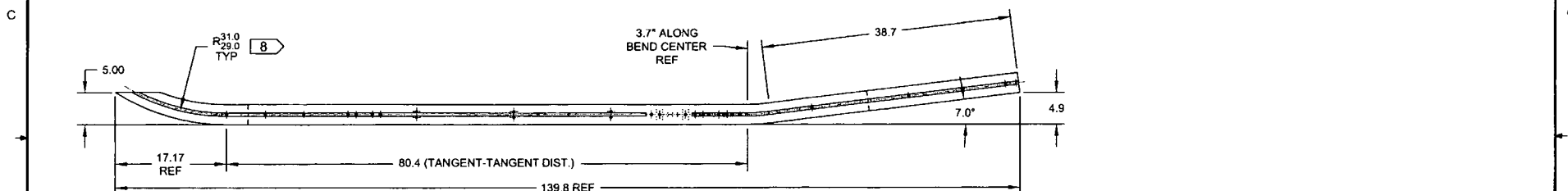
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DRAWN	CP	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. G
MFG. APPR.		D3288	SHEET 1 OF 4
APPROVED		TITLE	SCALE
DE APPR.		SKIDTUBE ASSEMBLY	NTS
DATE	09.06.17	COPYRIGHT © 2004 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

79406

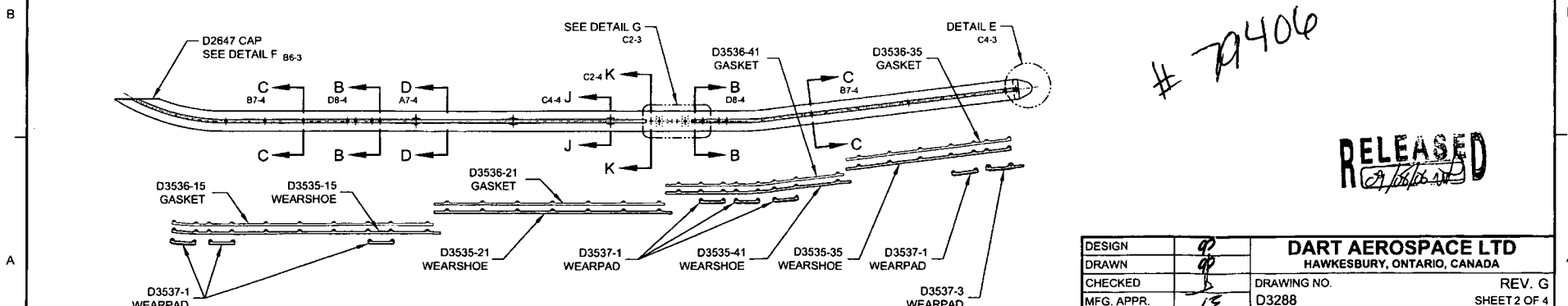
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D3288-041 DRILLING/WEB ASSEMBLY DETAIL



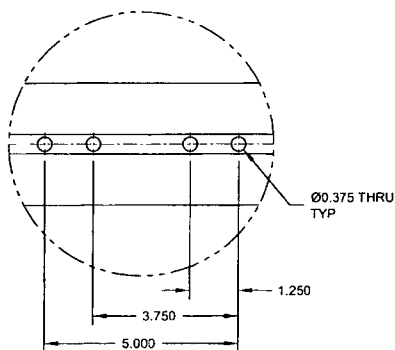
D3288-041 BENDING DETAIL



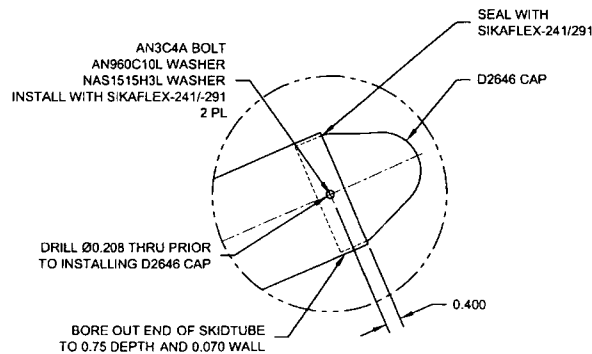
D3288-041 WELDING DETAIL/SKIDTUBE ASSEMBLY

DESIGN	92	DART AEROSPACE LTD	
DRAWN	92	HAWKESBURY, ONTARIO, CANADA	
CHECKED	13	DRAWING NO. D3288	REV. G
MFG. APPR.	13		SHEET 2 OF 4
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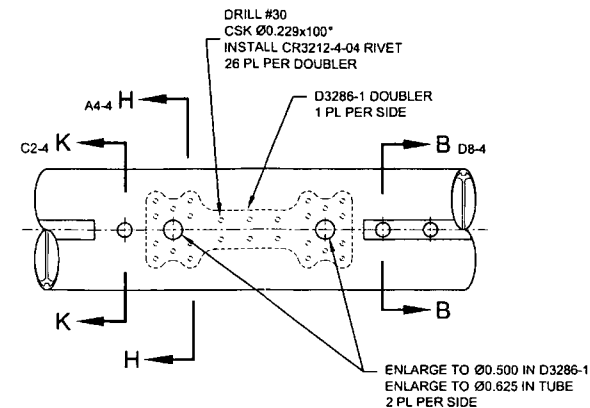
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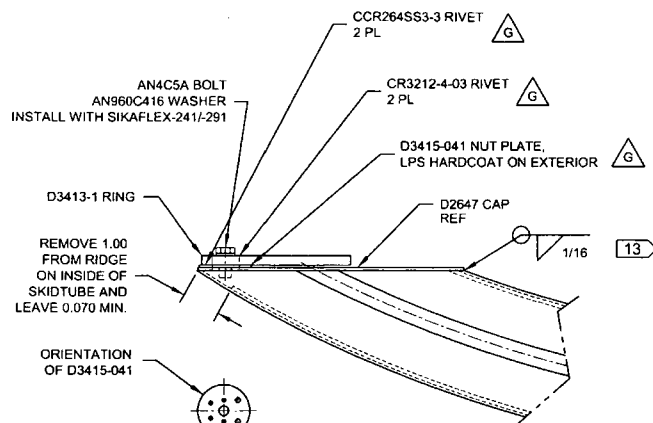
DETAIL A: DRILL DETAIL D6-2, D4-2
SADDLE HOLES, SCALE 5X



DETAIL E B3-2
SCALE 5X



DETAIL G B5-2
SCALE 5X



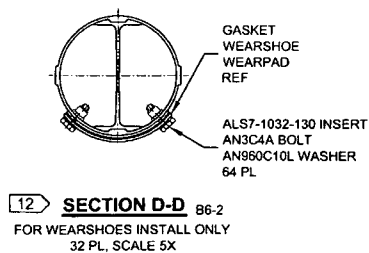
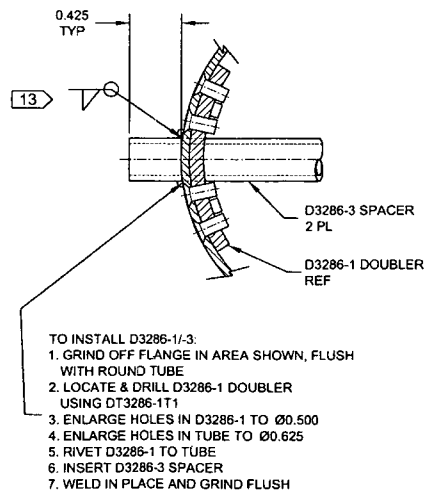
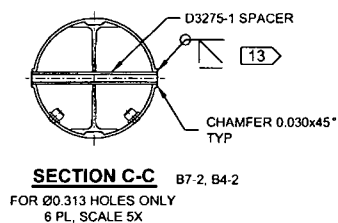
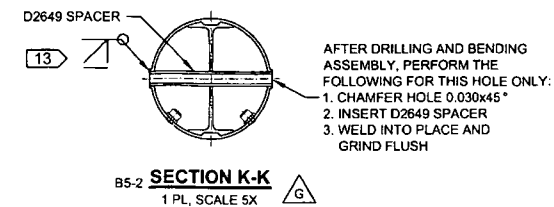
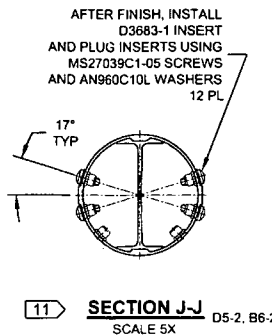
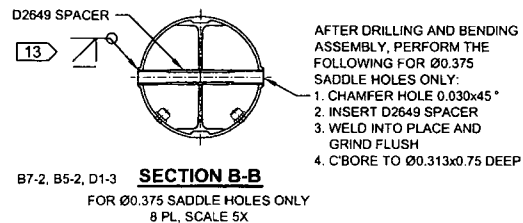
- DETAIL F NOTES**
1. CUT TUBE LEVEL
 2. REMOVE RIDGE ON FWD SIDE
 3. LOCATE D2647 (TRIM AS NECESSARY)
 4. WELD D2647 IN PLACE PER DART QSI 004
 5. GRIND FLUSH
 6. RIVET D3415-041 NUT PLATE IN PLACE
NOTE: MASK THREADS IN D3415-041 PRIOR TO FINISH

DETAIL F: END FINISHING DETAIL B7-2
SCALE 5X

#79404

RELEASED
09/06/17

DESIGN	99	DART AEROSPACE LTD	
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DE APPR.	99	SKIDTUBE ASSEMBLY	NTS
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79406

RELEASED
69/12/16

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DRAWN	99	HAWKESBURY, ONTARIO, CANADA	
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MFG. APPR.	99	D3288	SHEET 4 OF 4
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4.9 206A/B HIGH GEAR FLOAT SKIDTUBES, TRI-BAG COMPATIBLE (D206-642)
 32.19 206A/B HIGH GEAR FLOAT SKIDTUBES, TRI-BAG COMPATIBLE (ICA-D206-642)

ITEM	QTY -611	QTY -612	QTY -613	QTY -614	QTY -641	QTY -654	PART NUMBER	DESCRIPTION
	X						D206-642-611	SKIDTUBE INSTALLATION, LH
		X					D206-642-612	SKIDTUBE INSTALLATION, RH
			X				D206-642-613	SKIDTUBE INSTALLATION, LH, THRU BOLT
				X			D206-642-614	SKIDTUBE INSTALLATION, RH, THRU BOLT




IS:

12B	16	16	16	16			D3672-7	WASHER
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WAS:

12B	16	16	16	16			D3672-5	WASHER
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#-794019

DESIGN	CP	DART AEROSPACE USA, INC PORT HADLOCK, WA	
DRAWN	CP		
CHECKED		DRAWING NO.	REV. A
MFG. APPR.	N/A	DSI 9467	SHEET 2 OF 2
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